

DAS
46
9-89

16/11/22

Tuesday, November 22, 2016 9:37:26 AM

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[illegible]

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Page 3

NS1

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

NR2

2016/11/23
BEB

Hand Finishing

Quality Control

DAS
41
9-89

16-11-80

SprayPaint

Spray Painting

Prime tempo grey as per dwg (note 2)
Batch: 134518

DAS
41
9-89

16-11-30

Work Order ID 153574

Tuesday, November 22, 2016 9:37:26 AM

153574

Page 4

Item ID: D4482-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Intercostal 5, RH
 Start Date: 11/23/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 11/24/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC14- Inspect Spray Paint	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: SH03	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89

5 DEC 05 2016 **DAS 6 9-89**

DAS 21 9-89

DEC 05 2016

16-12-05

Picklist Print

Tuesday, November 22, 2016 9:37:31 AM

Page 1 /

Work Order ID: 153574

153574

Parent Item: D4482-2

D4482-2

Parent Item Name: Intercostal 5, RH

Start Date: 11/23/2016

Required Date: 11/24/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.12.04 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	169.7300	0.15	0.789474			
M6061T6S 063												DAS	
6061-T6 .063 Sheet												46	
												9.89	11/22/16

Location

Loc Qty

Loc Code

MAT021

169.73

M133511

2.6

M134377

3.3

M134830

163.83

0.9

DART AEROSPACE LTD		Work Order: 153574
Description:		Part Number: 04482-2
Inspection Dwg: D4482 Rev: C		Page 1 of 1

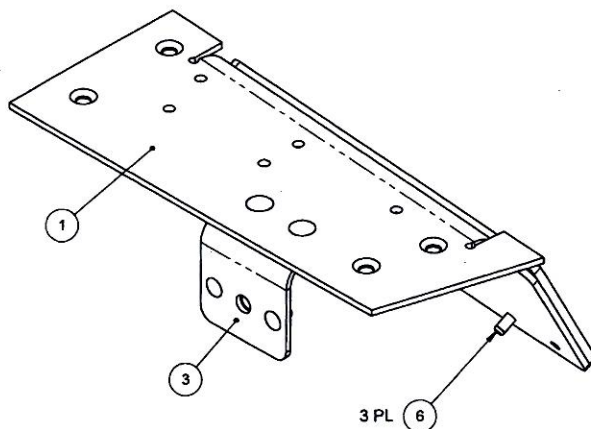
INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
0.098	+0.004 -0.001	0.100	✓		DC-02	
0.129	+0.005 -0.001	0.132	✓			
0.625	+/- .010	0.627	✓			
0.59	+/- .030	0.591	✓			
0.43	+/- .030	0.428	✓			
0.500	+/- .010	0.506	✓			
0.44	+/- .030	0.442	✓			
0.88	+/- .030	0.881	✓			
1.250	+/- .010	1.254	✓			
1.250	+/- .010	1.253	✓			
1.116	+/- .010	1.118	✓			
2.50	+/- .030	2.506	✓			
1.00	+/- .030	1.004	✓			
0.38	+/- .030	0.379	✓			
4.72	+/- .030	4.717	✓			
Manual Milling						
0.50	+/- .030	0.506	✓			
1.000	+/- .010	1.003	✓			
4.21	+/- .030	4.212	✓			
2.80	+/- .030	2.806	✓			
2.02	+/- .030	2.023	✓			
1.06	+/- .030	1.064	✓			
0.25	+/- .030	0.254	✓			
0.79	+/- .030	0.795	✓			
3.000	+/- .010	3.006	✓			
0.750	+/- .010	0.754	✓			
2.257	+/- .010	2.262	✓			
0.438	+/- .010	0.441	✓			
1.817	+/- .010	1.822	✓			

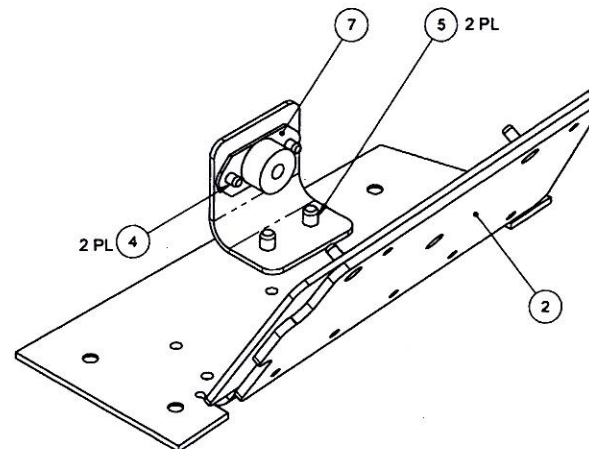
Measured by: 46 9-89	Audited by: DAS 38	Preliminary Approval:
Date: 16/11/22	Date: NOV 7 2016	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D4482-041	INTERCOSTAL 5 ASSY (LH)
1	1	D4482-1	INTERCOSTAL 5 (LH)
2	1	D4482-3	HINGE PLATE (LH)
3	1	D4488-1	CLIP
4	2	MS20426AD3-3	RIVET, CSK
5	2	MS20426AD4-4	RIVET, CSK
6	3	MS20426AD3-5	RIVET, CSK
7	1	MS21059L08	NUTPLATE



D4482-041 INTERCOSTAL 5 ASSY (LH)

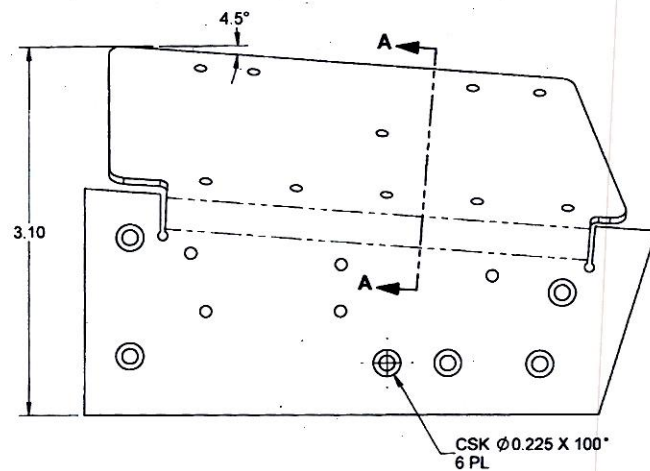


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2012-11-29
WP

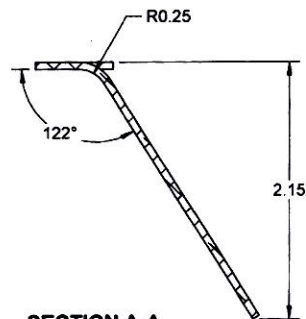
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153574

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs

C	ADDED -042 & -2 (RH CONFIGURATION).	AJS	12.10.05
B	GENERAL REVISION SEE REV. A FOR DETAILS. ADDED -3. ADDED PRIMER NOTE.	AJS	12.09.11
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4482	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	INTERCOSTAL 5 ASSY	NTS
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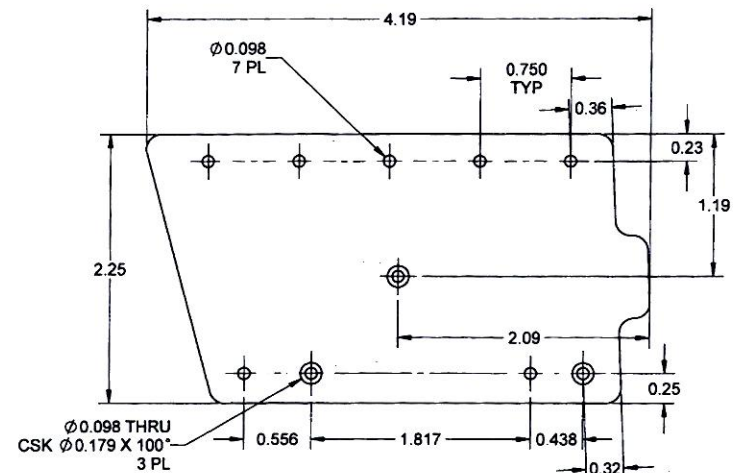
D4482-1 INTERCOASTAL 5 (LH)



SECTION A-A

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



D4482-3 HINGE PLATE (LH)

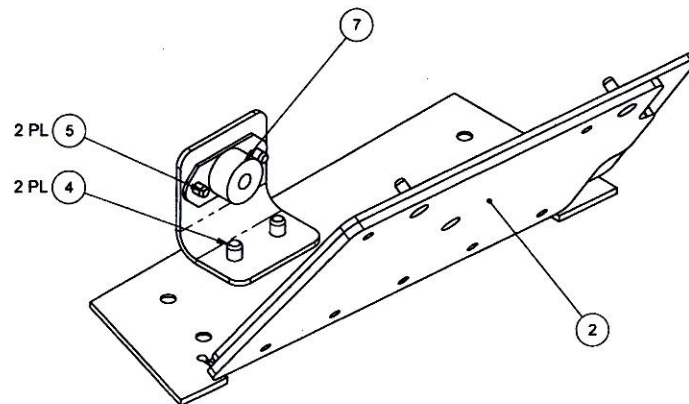
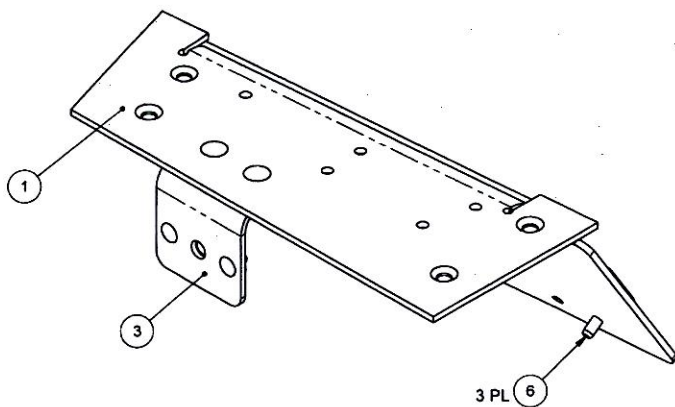
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REV.C.DXF"

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4482	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INTERCOASTAL 5 ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D4482-042	INTERCOSTAL 5 ASSY (RH)
1	1	D4482-2	INTERCOSTAL 5 ASSY (RH)
2	1	D4482-4	HINGE PLATE (RH)
3	1	D4488-1	CLIP
4	2	MS20426AD4-4	RIVET, CSK
5	2	MS20426AD3-3	RIVET, CSK
6	3	MS20426AD3-5	RIVET, CSK
7	1	MS21059L08	NUTPLATE

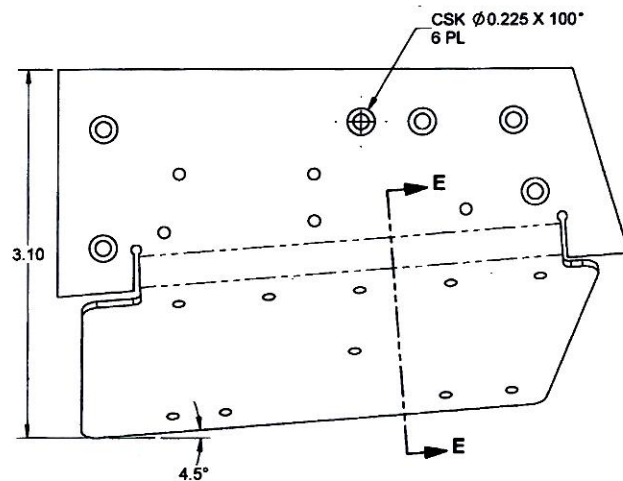


NOTES:

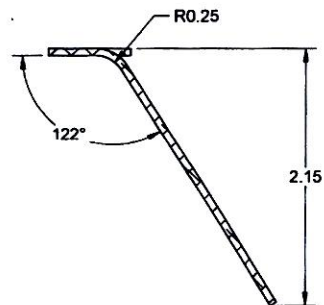
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO. D4482	REV. C
MFG. APPR.	JS	SHEET 3 OF 5	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	INTERCOSTAL 5 ASSY	NTS
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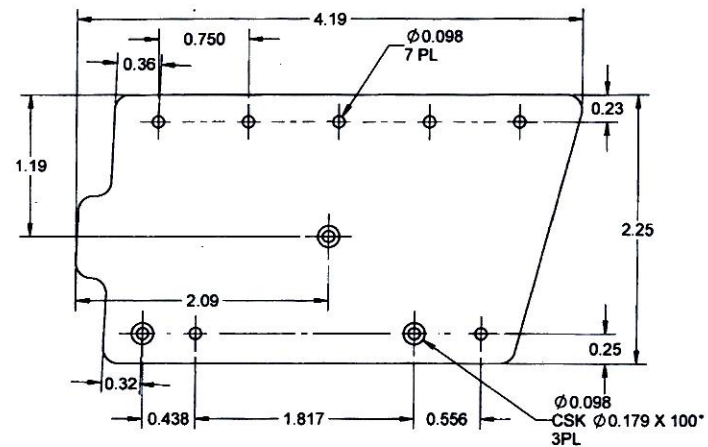
D4482-2 INTERCOSTAL 5 ASSY (RH)



SECTION E-E

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



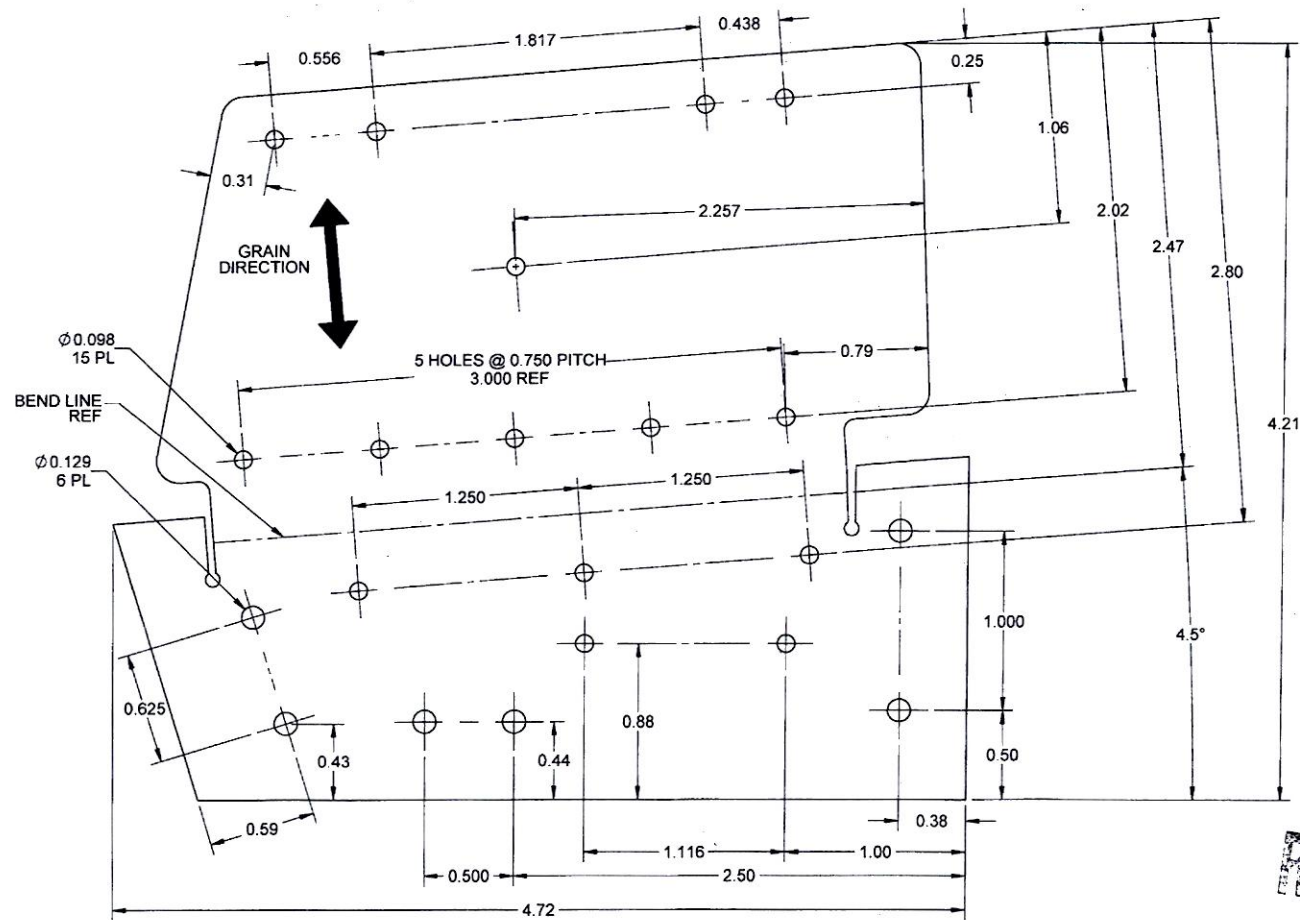
D4482-4 HINGE PLATE (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REV.C.DXF"

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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4482	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INTERCOSTAL 5 ASSY	NTS
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2012-11-29
MD

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-1F-REV.C.DXF"

8 D4482-1F INTERCOSTAL 5
(FLAT PATTERN)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>R</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>R</i>	D4482	SHEET 5 OF 5
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>#</i>	INTERCOSTAL 5 ASSY	NTS
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